



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3220-041
Job Sheet 183760



Part No: D3220-041

Job Qty: 10 ea

Part Name: Doubler Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/26/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:A New Issue 05-11-06 JLM IPP: B 06.11.15 waterjet EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		10/12/18	0.00	0.00	Start Up Waterjet		SC 18/10/18
100	Waterjet - B4B	10 pcs		10/12/18	0.10	1.08	Waterjet1		SC 18/10/18
110	QC	10 pcs		10/12/18	0.00	0.00	QC2 Waterjet-1		SC 18/10/18
120	QC	10 pcs		10/12/18	0.00	0.00	QC8-2		OCT 01 2018 68
130	Small Fab	10 pcs		10/12/18	0.00	0.71	Small Fab-3		OCT 02 2018 68
140	QC	10 pcs		10/12/18	0.00	0.00	QC5		OCT 02 2018 68
150	HandFinish	10 pcs		10/12/18	0.00	0.74	HandFinish1		OCT 02 2018 68
160	QC	10 pcs		10/12/18	0.00	0.00	QC3		OCT 02 2018 68
170	Small Fab	10 pcs		10/12/18	0.00	0.71	Small Fab-3		OCT 02 2018 68
180	QC	10 pcs		10/12/18	0.00	0.00	QC5		OCT 02 2018 68
190	Packaging	10 pcs		10/12/18	0.00	0.00	Packaging3-1		OCT 19 2018
200	QC21-SA	10 Ea		10/12/18	0.00	0.00	QC21		OCT 19 2018

Part Op 100 - 1-Cut D3220-1 as per Dwg D3220 Dwg Rev: B
Descriptions: 130 - 1-Debur 2-C'sink D3220-1 as per Dwg D3220
170 - Assemble D3220-041 doubler as per Dwg D3220

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	6.9260 sf (.6926 ea)	90-Start up Operation	M137626
MS20426AD3-3	Rivet	80 Ea (8 ea)	170-Small Fab	5018535
MS21059L4	Nutplate	40 Ea (4 ea)	170-Small Fab	5074203 36x
				5115613 4x

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.050	7	55	0
170-Small Fab	MS20426AD3-3	80	3,573	0
	MS21059L4	40	47	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐	
Cross tube ☐	Water Jet ☐	Engineering ☐													
Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐													
Finishing ☐	Rec/Store/Packaging ☐	Other ☐													
Composite ☐	Supplier ☐														
Date : _____		MRB (QSI042) Approval													
16111 Aerodrome Street Markham, ON M3A 1K7 CANADA TEL: 1 913 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S114828 Part: D3220-041 Job No: 183760 Serial No/Batch: S114828 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 10/01/18		Disposition	Completed By												
		Lead hand / Supervisor Approval Verification													
		QC / QA Coordinator Approval													
		CATEGORY													
Environm Des Doc/Di Equip/Tool Handling/Pi Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified	Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due	Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes	Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center	Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence										
OTHER : _____															

DART AEROSPACE LTD		Work Order: 183760
Description: Doubler		Part Number: D3220-1
Inspection Dwg: D3220	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.50	+/-0.030	5.506	1		VSC01	
14.25	+/-0.030	14.251	1		Tape	
R0.50	+/-0.030	R0.50	1			
7.00	+/-0.030	7.005	1			
7.000	+/-0.005	7.002	1			
1.50	+/-0.030	1.504	1			
1.000	+/-0.005	1.002	1			
0.500	+/-0.005	0.501	1			
1.000	+/-0.005	1.001	1			
Ø 0.316	+0.005/-0.000	Ø 0.317	1			
Ø 0.098	+0.005/-0.000	Ø 0.099	1			
0.050 thick	+/-0.005	0.048	1			
Grain Direction	N/A	OK	1			

DAS
68
9-89
OCT 01 2018

Measured by: SC	Audited by:	Prototype Approval:	N/A
Date: 10/01	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.27	New Issue P/O D3220-041	KJ/RF	
B	10.02.02	Dwg Rev updated	KJ	